

Work Order ID 68632

Tuesday, April 19, 2011 11:53:42 AM



Page 1

Item ID: D2894-1

Revision ID:

Item Name: 2.750 Support

Start Date: 4/19/2011 Start Qty: 6.00

Required Date: 4/25/2011 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 4-19-11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2894

Rev D

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FA253
Tumble & Deburr

0.00

0.00

Rq 11.8.2

3

110



QC

Quality Control

QC1- Inspect dimensions to dimension sheet

Memo

0.00

0.00

Rq 11.8.2

3

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

SA 11.8/2

3

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Setup Start



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Customer:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160



SprayPaint

SprayPaint

0.00

Memo

0.00

Spray Painting

HAND FINISHING RESOURCE #1
Mask and prime inside surface as per dwg D2894 per Dart QSI 005 4.2

RT 11-08-06

170



QC

QC14- Inspect Spray Paint

0.00

Memo

0.00

Quality Control

3 11-08-11

180



Packaging

Identify as per dwg & Stock Location: x kula

0.00

Memo

0.00

Packaging

RT 11-08-11

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Required Date: 4/25/2011 Req'd Qty: 6.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/12

11/08-11

(3)

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Picklist Print

Tuesday, April 19, 2011 11:53:49 AM

Page

Work Order ID: 68632

Parent Item: D2894-1

Parent Item Name: 2.750 Support



Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B 02.11.26 Added mask hole KJ
 IPP Rev:C ECN 993 07-11-07 DD verified by:EC
 IPP D 08.03.19 Re-format EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DSK079



D2894-1 TURNING DETAIL

Manufactured

No

Each

7.0000



3

11.8.2

Location

MAT060

43976 ✓

Loc Qty

7

7

Loc Code

3

H:\FORMS\Quality Assurance\approved

NOTE: Date & initial all ent.

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DART AEROSPACE LTD		Work Order:	48632
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.454	0.474		.464	.464	.464		
AB	3.062	3.082		3.072	3.072	3.072		
AC	0.053	0.073		.063	.063	.063		
AD	1.766	1.786		1.772	1.778	1.779		
AE	0.020	0.040		.030	.030	.03		
AF	0.260	0.267		.261	.261	.261		
AG	0.170	0.190		.185	.185	.185		
AH	0.150	0.170		.170	.170	.170		
AI	1.990	2.010		2.001	2.002	2.004		
AJ	0.240	0.260		.260	.260	.260		
AK	1.880	1.900		1.894	1.883	1.890		
AL	0.500	0.505		.500	.500	.500		
AM	0.188	0.194		.188	.188	.188		
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

22.02

3.105

22.02
11

Measured by:	<i>[Signature]</i>	Date:	11.8.2
Audited by:	<i>[Signature]</i>	Date:	11/8/2
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	<i>[Signature]</i>

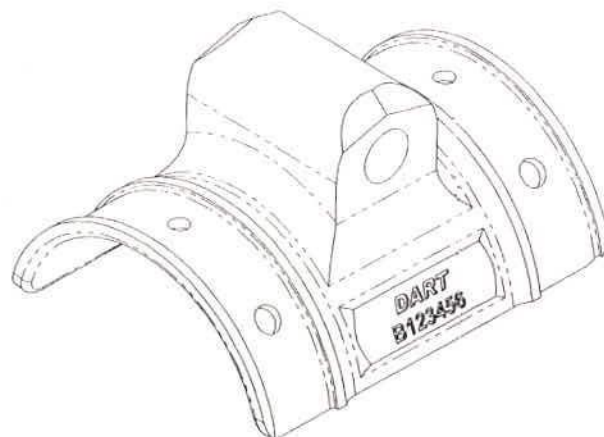
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D2894-1 Ø2.750 SUPPORT

STANDARD COPY
 REVISIONS
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 68632

11/04/19

RELEASED
 08/11/19

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
 HEAT TREAT TO H900 CONDITION
 (900°F FOR 1 HR, AIR COOL)
 MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,
 WITH R0.25 RADIUS OF TRANSITION IN THIS AREA.
 IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE
 SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE
 SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs



D	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM. PER BELL TECH BULLETIN 407-08-84. B2-2 0.251 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2894 TITLE Ø2.750 SUPPORT SCALE NTS COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO YOU FOR YOUR USE ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED			
MFG. APPR			
APPROVED			
DE APPR			
DATE	08.11.06		

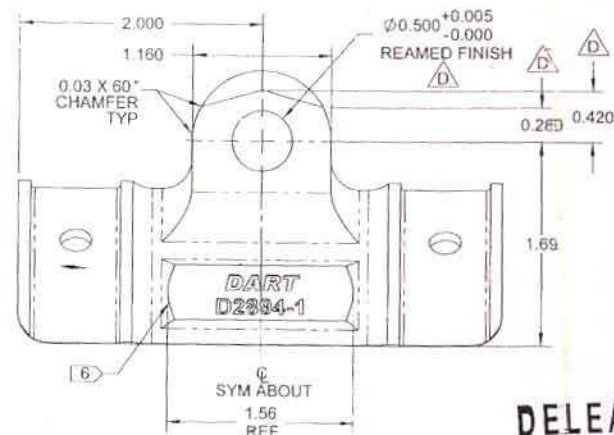
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D2894-1 Ø2.750 SUPPORT

RELEASED
08/11/19 MP

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2894	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
DATE	08.11.06	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS SPECIFICALLY DESIGNED.</small>	

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